

SWAGE NIPPLES and BULL PLUGS

GENERAL INFORMATION

Capitol Manufacturing Company's Carbon Steel Swage Nipple Products are manufactured in accordance with the ASME/ASTM SA234WPB and MSS-SP95 specifications. The raw materials used in manufacturing these products are A106 Grade B Seamless pipe and/or cold drawn, low to medium carbon, barstock. As a rule, 1" and smaller sizes will be made from hex barstock and most 1 1/4" and larger sizes will be made from pipe. Where pipe is not a practical raw material, round barstock will be used. No sacrifice of properties will result from this practice.

Capitol Swage Nipple Products are marked as follows:

Size and Schedule:

Size of fitting and pipe schedule/weight

Manufacturer's Logo:



Heat Code I.D.:

Fittings are steel stamped with a series of Alpha and Numeric codes fully traceable to the original raw material test report.

Labeling:

Carbon Steel - Size and Schedule or weight (where space is available)

Oil Country - Size Only

Material Grade:

WPBN (Line Pipe Sizes) A234WPBN

J55, K55 N80, etc. (Oil Country Sizes)

Stainless & Alloy will be stamped with their proper ASTM specification.

Heat Treatment:

All Carbon Steel Swage Products are furnished in a Normalized condition and marked with the letter "N". Oil Country Sizes pressed from pipe or tubing will be Normalized. These sizes are marked as Normalized to avoid any confusion with the symbol for N-80 material.

Specification Compliance Data for Swage Nipples and Bull Plugs

End Connections

Threads	ANSI/ASME	B1.20.1
	API	5B
Beveled Ends	ANSI	B16.9
Square Cut Ends	ANSI	B16.11

Raw Materials

Carbon Steel	ASME/ASTM	SA106, GRB, A696
Stainless	ASME/ASTM	SA312 & 182
Chrome & Low Temp	ASME/ASTM	SA335, 333, 182, 350
Nickel Alloy	ASME/ASTM	SB161, 165, 163, 407, 464, 622, 160, 164, 166, 408, 473, 619

Coatings

Zinc Electro Plate	ASTM	B633
Phosphate	Capitol	Zinc Phosphate
Painted	---	Acrylic Lacquer
Hot Dip Galvanized	ASTM	A153

Swage Nipples

Carbon	ASME/ASTM	SA234WPB
Stainless	ASME/ASTM	SA403WP
Low Temp	ASME/ASTM	SA420WP
Nickel Alloy	ASME/ASTM	SB366

Package Quantities

Swage Nipples and Bull Plugs

1/8" to 1/2"	XH, 160 & XXH	24 pcs
3/4" to 1 1/2"	XH, 160 & XXH	12 pcs
2"	STD, XH, 160 & XXH	12pcs

Swage Nipples

2 1/2"	STD & XH	12 pcs
2 1/2"	160 & XXH	6 pcs
3"	STD & XH	12 pcs
3"	160 & XXH	6 pcs
4"	STD & XH	6 pcs
4"	160 & XXH	4 pcs
5" & 6"	STD & XH	2 pcs

Bull Plugs

2 1/2"	STD & XH	12 pcs
2 1/2"	160 & XXH	6 pcs
3"	STD & XH	6 pcs
3"	160 & XXH	4 pcs
4"	STD & XH	6 pcs
4"	160 & XXH	4 pcs

Oil Country

2 1/2"		12 pcs
3"		6 pcs
4"		6 pcs

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